

Work Order ID 55126

January 06, 2010 3:24:38 PM



Page 1

Item ID: D3954-3

Accept



Setup Start



Revision ID:

Item Name: GWT Knob

Stop



Start Date: 1/6/2010 Start Qty: 10.00



Cust Item ID:



Required Date: 1/13/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-01-06 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
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D3954	B								
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100		0.00							
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Waterjet	Memo	0.00							
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FLOW CNC Waterjet	1-Cut as per Dwg D3854								
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	Dwg Rev: 10-01-11								
--	-------------------	--	--	--	--	--	--	--	--

	Prog Rev: 10-01-11								
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	2-Deburr if necessary								
--	-----------------------	--	--	--	--	--	--	--	--

	=> M-L 10/01/12								
--	-----------------	--	--	--	--	--	--	--	--

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110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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QC	Memo	0.00							
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Quality Control									
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10-01-11

6

7X

10-01-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55126

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

⇒ S10/01/12



130



Mill Conv

Conventional Milling Machine

Memo

0.00

M.A 10/01/12

7

Ø

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

⇒ S10/01/13

0.00



W/O:		WORK ORDER CHANGES					
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Work Order ID 55126

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Item ID: D3954-3

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Setup Start



Revision ID:

Item Name: GWT Knob

Stop



Start Date: 1/6/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 1/13/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date: Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

150



SprayPaint

Spray Painting

Operation
Description

M1113544

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

Memo

0.00

0.00

Start: 2:18pm
Temp: 370°C
Stop: 2:45pm

10-01-13 X7

Powder coat hybrid yellow HS112 Y12 (Ref. PAR10-001 1/6/01.07)

JOC4 Inspect Spray Paint
JOC3

Memo

BK 10-01-14.

170



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

10/11/14 C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 55126

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Item ID: D3954-3

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Setup Start



Revision ID:

Item Name: GWT Knob

Stop



Start Date: 1/6/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 1/13/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

180



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

Memo

10/01/15 JF

MF 10-1-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 55126



Parent Item: D3954-3

Parent Item Name: GWT Knob

Comments:

Start Date: 1/6/2010

Required Date: 1/13/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1010B0.375X03.500		Purchased	No			100	f	13.9600	0.2924	1.5		
1010-1025 Steel Bar .375 x 3.500											10-1-11	

Warehouse

Location

Main Warehouse

MAT	13.96
102179	2.46
110740	11.5
111369	

Loc Qty

Loc Code

N/A
N/A
111369

7

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order:	55126
Description: GWT Knob	Part Number:	D3954-3
Inspection Dwg: D3954 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	R	Audited by:	S	Prototype Approval:	N/A
Date:	10-1-11	Date:	10/01/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.06.11	New Issue	KJ	
B	09.11.04	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

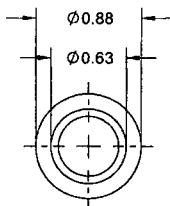
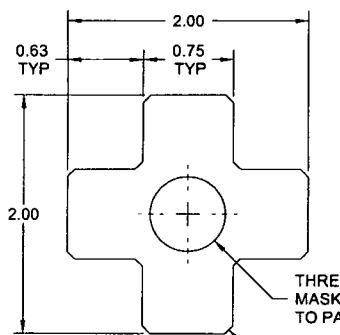
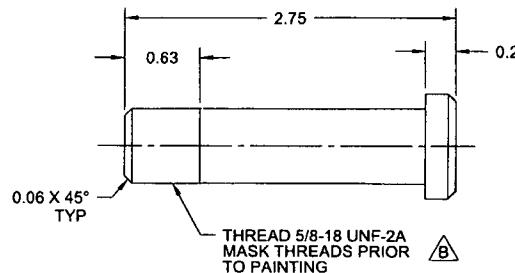
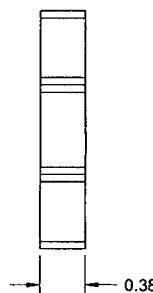
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8 7 6 5 4 3 2 1

D3954-1 GWT PIND3954-3 GWT KNOB

NOTES:
1) MATERIAL -1: AISI 1010-1025 MILD STEEL ROUND BAR
PER DART SPEC M1018-R

-3: AISI 1010-1025 MILD STEEL SHEET
PER DART SPEC MS1010-S

OR: AISI 1010-1025 MILD STEEL BAR
PER DART SPEC M1010-B

ALTERNATE MATERIAL:

-1: AISI 303/304 STAINLESS STEEL ROUND BAR
REF DART SPEC M303/304R

-3: AISI 303/304 STAINLESS STEEL SHEET
REF DART SPEC M303/304S

OR: AISI 303/304 STAINLESS STEEL BAR
REF DART SPEC M303/304B

2) FINISH: SPRAY-PAINT YELLOW WITH BERTRAND CG1091B PER DART QSI-005.4.2

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -1: 0.26 lbs

-3: 0.23 lbs



10/01/07
MJD/bj/07
Powder Coat Hybrid Yellow Ref. PAR10-001

RELEASED
2009-10-19

MJ

DESIGN	AJS/DSTOW	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. B
APPROVED		D3954
DE APPR.	N/A	SHEET 2 OF 3
DATE	09.10.15	MISC MACHINED PARTS GWT KIT NTS

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